

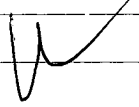
# Work Order ID 86502

**\*86502\***

Page 1

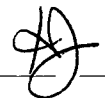
July-03-12 9:20:24 AM

Item ID: D412-742-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Replacement Float Skidtube  
 Start Date: 7/03/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 7/05/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan:  Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100 0.00  
**\*100\*** DOCUMENT CONTROL  
 DC Memo 0.00  
 Document Control If D412-742-043 is a W/O on it's own,  
 Photocopy bluefile and create labels per PPP D412-742-043 CHG005

N/A 

# Work Order ID 86502

\*86502\*

Page 2

July-03-12 9:20:24 AM

Item ID: D412-742-043 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Replacement Float Skidtube  
 Start Date: 7/03/12 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 7/05/12 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	HandFinishing	0.00							
*110*	HandFinish	0.00				1x	6	11	1267105
Hand Finishing	<div><div>Memo</div><div>1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins. A/RSikaflex-241/-291 11121409 Expiry date: 13103</div><div>2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.</div><div>A/RSikaflex-241/-291 11121409 Expiry date: 13103</div><div>3-Remove "T" pins once sikaflex is dry.</div><div>4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/RLPS Procyon 11114596</div></div>								

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Item ID: D412-742-043

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Float Skidtube

Start Date: 7/03/12 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/05/12 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130		0.00							
<b>*130*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-043								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

12.07.30

# Picklist Print

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Page 1

Work Order ID: 86502

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 7/03/12

Required Date: 7/05/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM  
 IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC  
 IPP Rev:C 07-05-28 As per Rev F JLM  
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM  
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F 11.11.01 as per DSI9517  
 REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3391-021 Fwd Tube Assembly		Manufactured	No			110	Each	0.0000		138236.1(x1)		11/07/03	
D3391-023 Mid Tube Assembly		Manufactured	No			110	Each	2.0000		138516.3(x1)		12/07/03	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP		2							
				85159		1							
D3391-025 Aft Tube Assembly		Manufactured	No			110	Each	2.0000		138470.2(x1)		12/07/03	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP001		1							
				84701		1							
				PAKG		1							
				84684		1							
AN3C4A BOLT		Purchased	No			110	Each	4,704.0000	24	24		12/07/03	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST350		4704							
				120187		31							
				120521		28							
				120769		38							
				121205		599				824			
				121556		8							
				122151		4000							

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Page 2

Work Order ID: 86502

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 7/03/12

Required Date: 7/05/12

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 110 Each 315.0000

10 yl 10 12/07/03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP00i	1	
111982	1	
ST351	314	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	21	
120423	3	
120693	118	
121682	104	

x10

AN3C7A Purchased No 110 Each 196.0000

4 yl 4 12/07/03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	196	
113149	14	
116169	1	
117313	10	
117619	12	
117688	6	
119749	1	
120731	8	
121185	42	
121541	2	
122141	100	

x4

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Page 2

# Picklist Print

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Page 3

Work Order ID: 86502

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 7/03/12

Required Date: 7/05/12

Start Qty: 1.00

Required Qty: 1.00

AN960C10L washer  
NAS1149C0332R Purchased No

110 Each 21.0000 38

38 12/07/03

Location

Loc Qty

Loc Code

ST 107534

21  
21

11122063 x38

D4095-041 Manufactured No  
 Wearplate Assembly

110 Each 8.0000 1

1 12/07/05

Location

Loc Qty

Loc Code

FP001 83809

8  
8

1385616 x1

D4095-043 Manufactured No  
 Wearplate Assembly

110 Each 8.0000 1

1 12/07/03

Location

Loc Qty

Loc Code

FP001 81624  
83479

8  
1  
7

1385615 x1

D4095-045 Manufactured No  
 Wearplate Assembly

110 Each 16.0000 1

1 12/07/03

Location

Loc Qty

Loc Code

FP001 77737  
84081  
85614

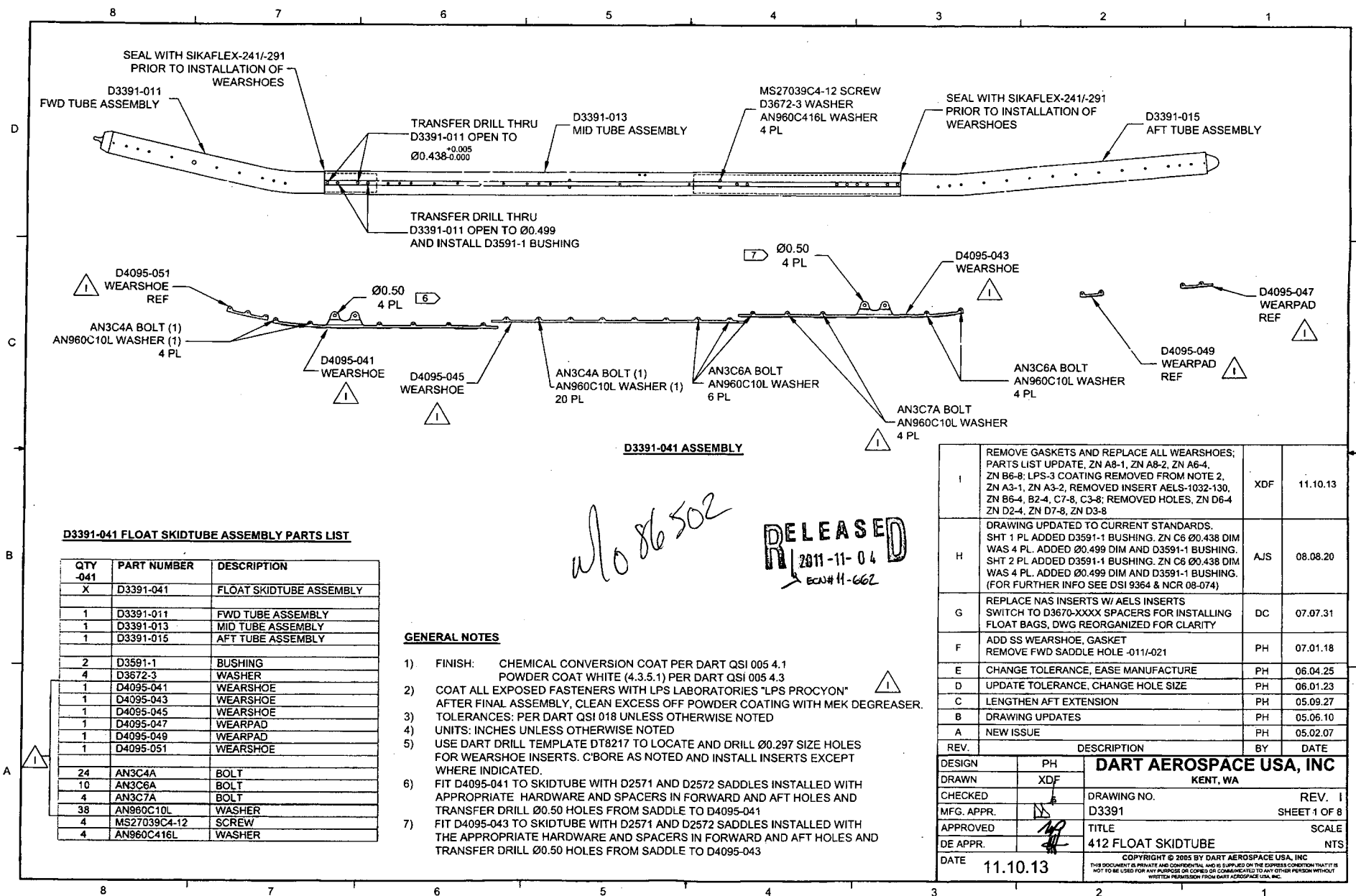
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1  
7  
8

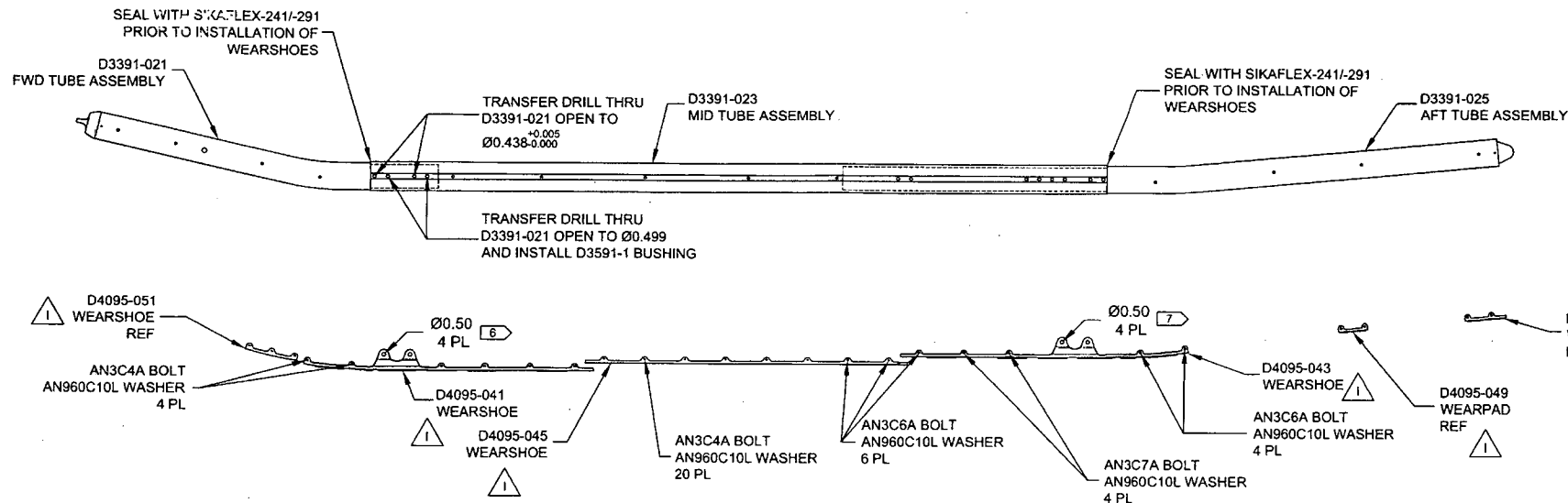
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**D3391-043 ASSEMBLY**





**D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

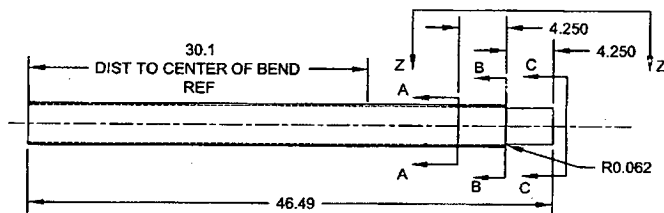
**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL  $\varnothing 0.297$  SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL  $\varnothing 0.50$  HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL  $\varnothing 0.50$  HOLES FROM SADDLE TO D4095-043

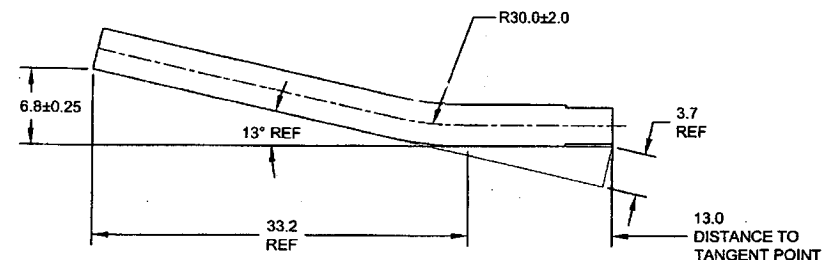
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MFG. APPR.		D3391	SHEET 2 OF 8	
APPROVED		TITLE	SCALE	
DE APPR.		412 FLOAT SKIDTUBE	NTS	
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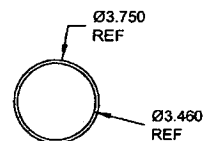




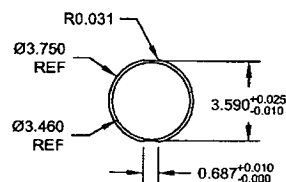
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(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



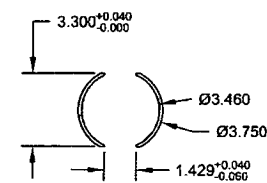
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



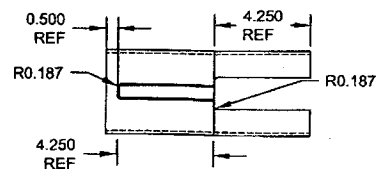
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**SECTION B-B**  
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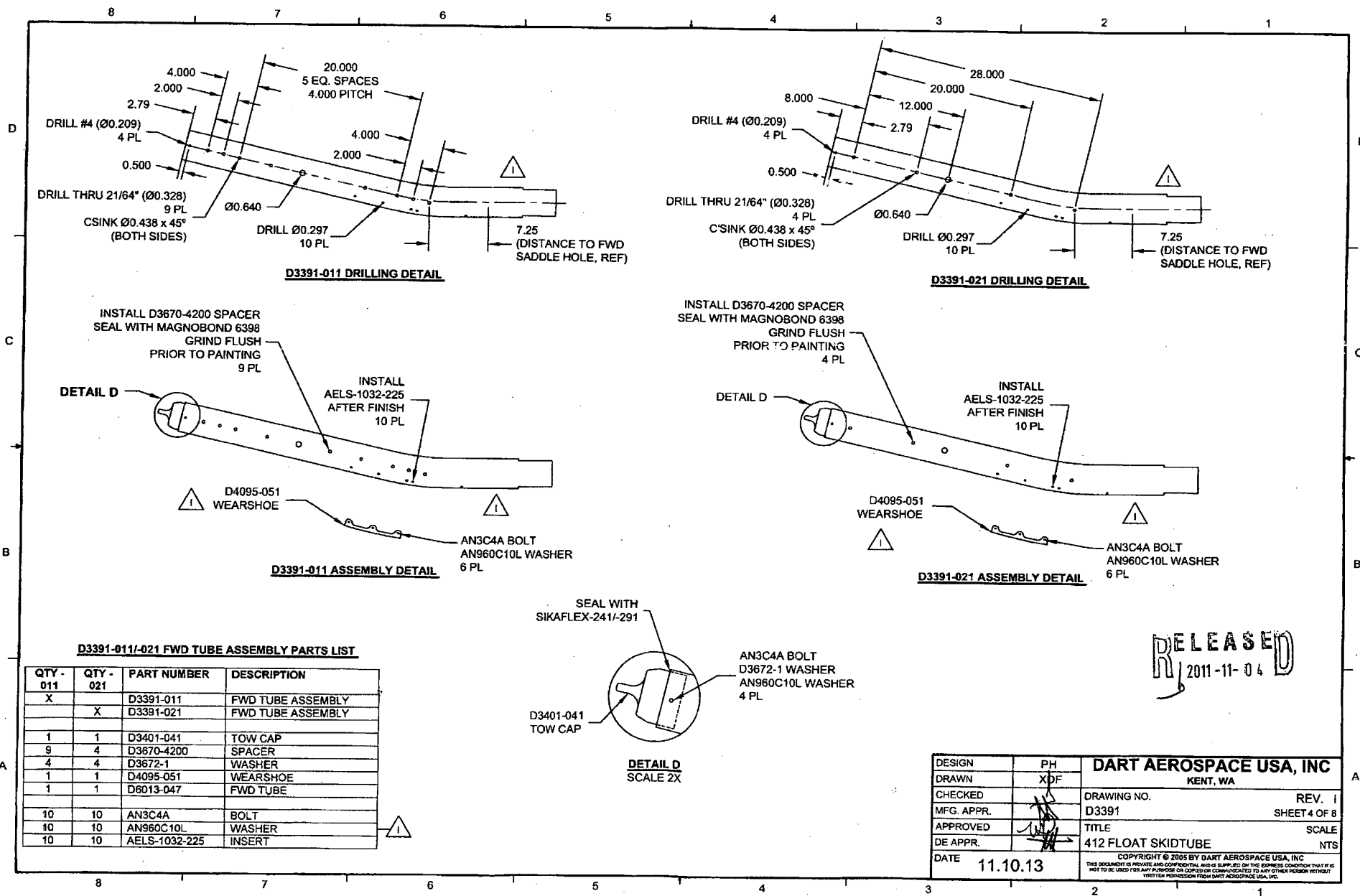
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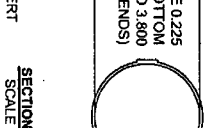
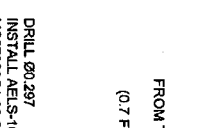
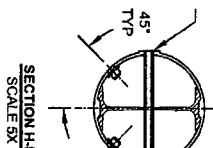
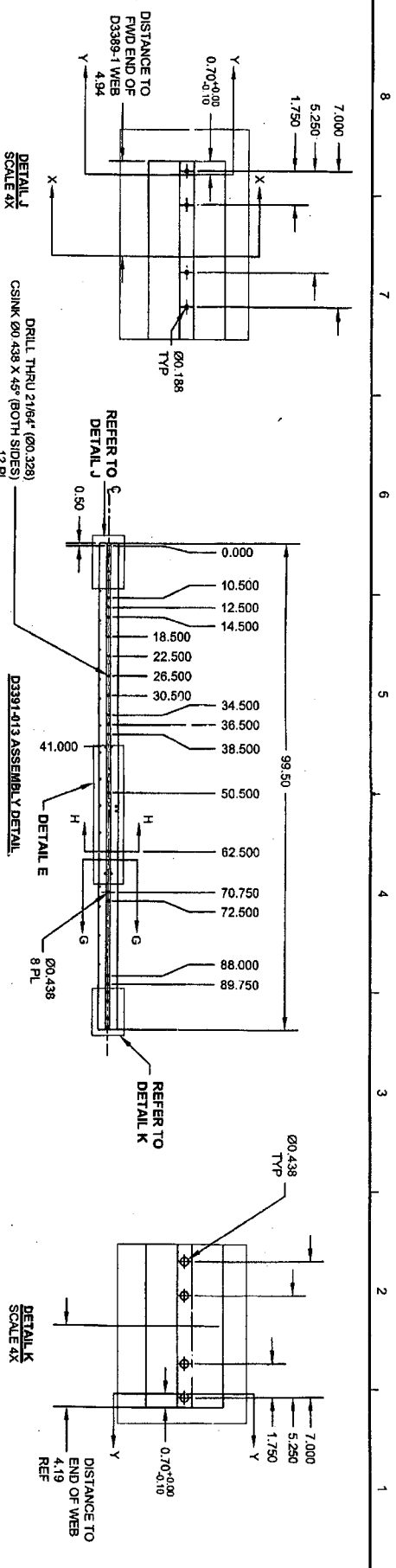


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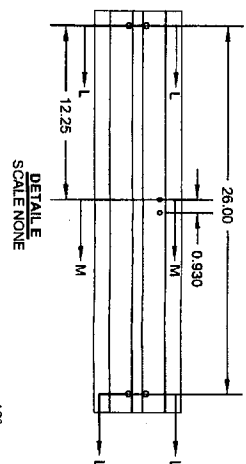
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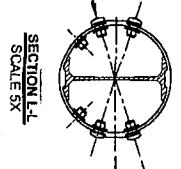


**D3391-013 MID TUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WASHER
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AEIS-1032-130	INSERT
4	ALS-428-165	INSERT
4	AN660C10L	WASHER
4	AN660C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



- D3391-013 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
  - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/297 PER CSI 015
  - 3) WELDING: PER PART CSI 004



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**412 FLOAT SKID TUBE**

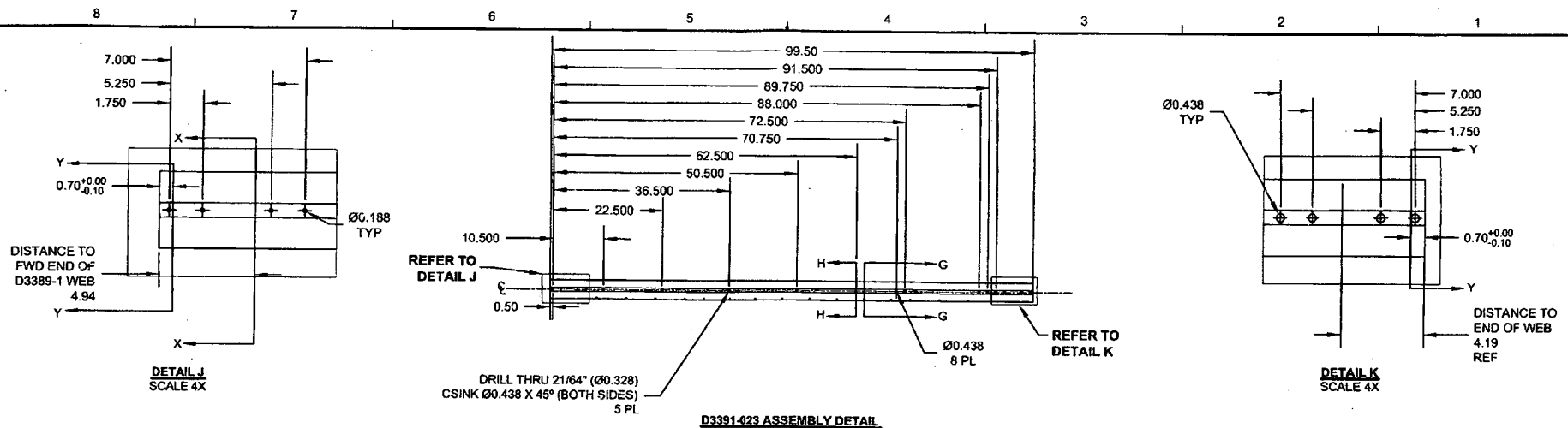
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**SHEET 5 OF 8**

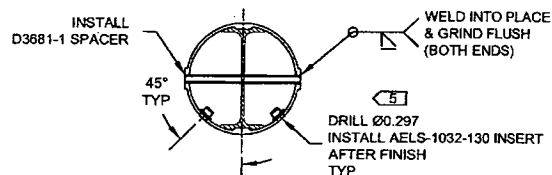
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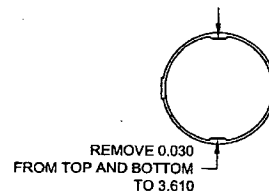
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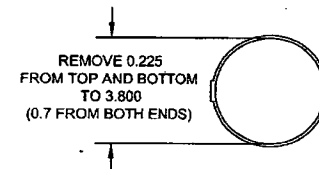
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SECTION H-H  
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SECTION X-X  
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SECTION Y-Y  
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**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

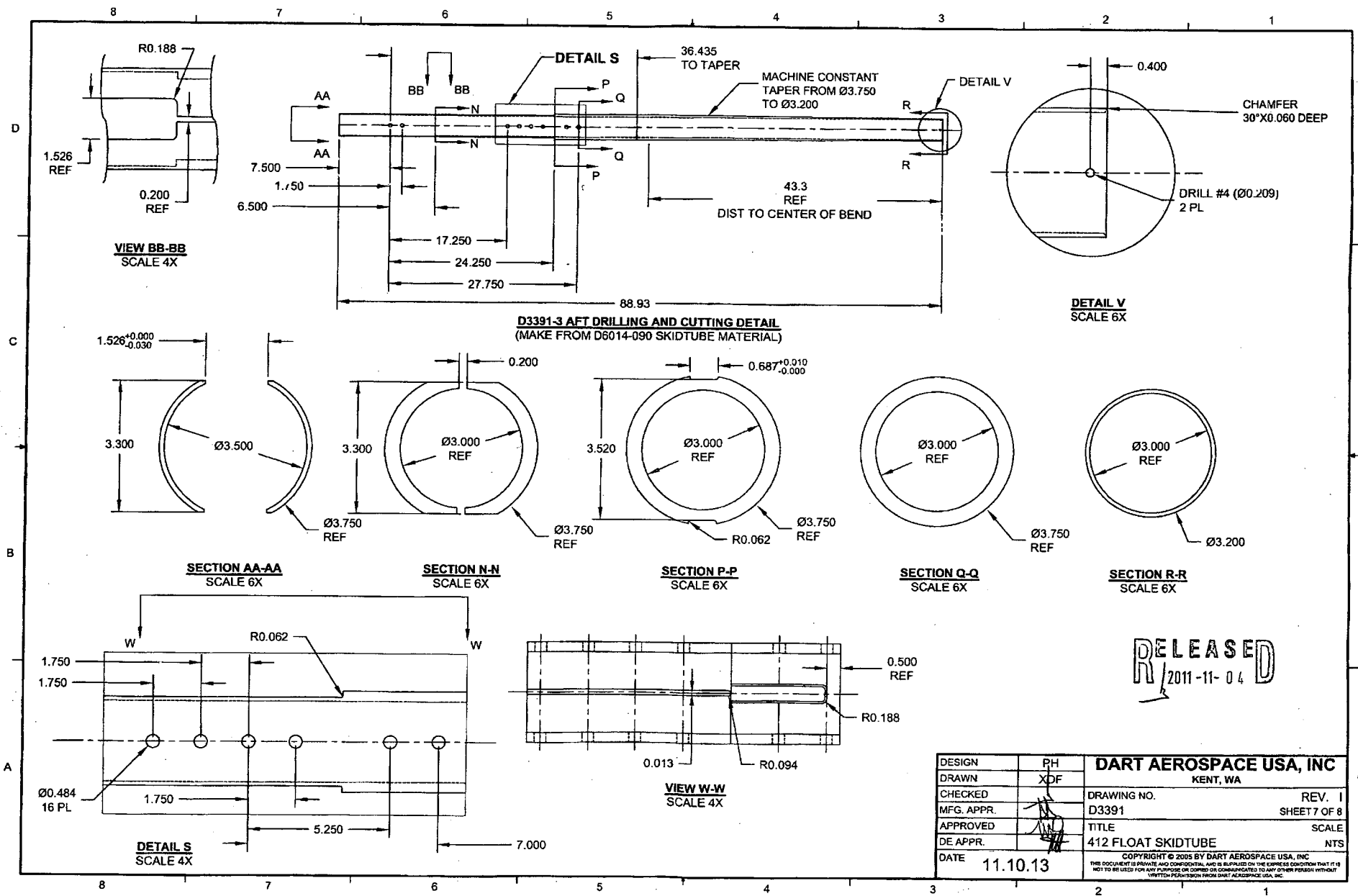
QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

**D3391-023 MID TUBE ASSEMBLY**

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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